

Work Order ID 160910

Friday, May 05, 2017 9:44:43 AM

160910

Page 1

Item ID: PB67-43001-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Adjustable Blade Support Assembly **DAS**
 Start Date: 5/15/2017 Start Qty: 7.00 **21** ***7*** Cust Item ID:
 Required Date: 6/2/2017 Req'd Qty: 7.00 **9-89** ***7*** Customer:
 Reference: SCHEDULED/U

Approvals: Process Plan: **DAS** Date: **MAY 05 2017** Tooling: Date: Run Start ***NR1***
 QC: **21** Date: SPC (Y/N): Date: Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-13	D

100 Weld per dwg A/R Aluminum rod Batch: **136158** 0.00 **DAS**
100 Large Fab **2** **JUN 07 2017** **24**
9-89

Large Fab Memo 3.50
 Large Fab 1- make a 0.090" chamfer in the 1.00" hole before welding
 2- grind weld flush in area of PB67-43001-249 only
 3- ASSEMBLE AND WELD AS PER DWG

102 0.00 **DAS**
102 Mill Conv **32**
 Conventional Milling Machine **9-89**

DRILL AND TAP FOR 1/2"-20 HELICAL INSERT
 INSTALL HELICAL INSERT **17-06-12**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐					
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐					
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐					
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐					
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐					
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐					
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐					
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐					
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐					
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐					
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____								
Misidentified ☐	☐	Past Due ☐									

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
105						(2)	17-06-12		
QC	Memo	0.14							
Quality Control									
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
110						(2)	17-06-12		
QC	Memo	0.14							
Quality Control									
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							DAS 34 9-89
160						2	17-06-12		
Powdercoat	Memo 11 134092	1.57							
Powder Coating	1- MASK TUBE FROM BASE TO GUSSET								

START TIME: 1:45
OVEN TEMPERATURE: 320
FINISH TIME: 2:15

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[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
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☐ OTHER : _____					

Work Order ID 160910***160910***

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Item ID: PB67-43001-13

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/15/2017 Start Qty: 7.00 ***7***

Cust Item ID:

Required Date: 6/2/2017 Req'd Qty: 7.00 ***7***

Customer:

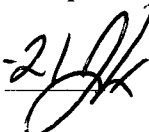
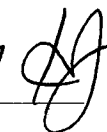
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>WA003</u>	0.00				2	0	17-6-2	
200									
Packaging	Memo	0.07							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00						17/6/27	
210									
QC	Memo	0.70							
Quality Control									



JUN 23 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____					

Picklist Print

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Work Order ID: 160910

160910

Parent Item: PB67-43001-13

PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/15/2017

Required Date: 6/2/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.27 per RevC EC verified by:DD

IPP RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS124780		Purchased	No			180	Each	12.0000	1	7			DAS 32 9-89
MS124780									**			17-06-12	

HELICAL INSERT

Location

Loc Qty

Loc Code

ST316

12

111064

12

M128 173

~~17-06-12~~ (Not pulled)

MS27039-1-10

Purchased

No

180

Each

287.0000

8

56

MS27039-1-10

JUN 19 2017

DAS
19
9-89

SCREW

Location

Loc Qty

Loc Code

GA

15

m129541

15

ST280

272

m137164

272

(16)

NAS1149D0316J

Purchased

No

180

Each

1,053.000

8

56

NAS1149D0316J

JUN 19 2017

DAS
19
9-89

Washer

Location

Loc Qty

Loc Code

ST264

1053

M134502

1053

(16)

DQA: _____ Date: _____

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Description Work Order Deviation		Disposition			
P.O. # _____ Date _____ By _____				Completed By	
				Lead hand / Supervisor Approval Verification	
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Parent Item: PB67-43001-13

PR67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/15/2017

Required Date: 6/2/2017

Start Qty: 7.00

Required Qty: 7.00

NAS1149D0363J

Purchased

No

180

Each

629.0000

42
50
6
8
10
12
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NAS1149D0363.I

Washer

Location	Loc Qty	Loc Code
GA	42	
m134055	42	
ST263	587	
m137061	100	
m137164	487	

PB67-43001-249

Manufactured

No

100

Each

4.0000

1

7

PR67-43001-249

Inner Tube Bushing

Location	Loc Qty	Loc Code
WA003	4	
133726	4	

PB67-43001-253

Manufactured

No

100

Each

0.0000

1

7

PR67-43001-253

Gusset

PB67-43001-254

Manufactured

No

100

Each

0.0000

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PR67-43001-254

Gusset

PB67-43001-255

Manufactured

No

100

Each

0.0000

1

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PR67-43001-255

Inner Tube

PB67-43001-67

Manufactured

No

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Each

0.0000

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PR67-43001-67

90° Blade Support Assembly

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JUN 19 2017

DAS
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9-89

12

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JUN 07 2017

DAS
24
9-89

B160831 → 2

PB67-43001-253

Manufactured

No

100

Each

0.0000

1

7

PR67-43001-253

Gusset

PB67-43001-254

Manufactured

No

100

Each

0.0000

1

7

PR67-43001-254

Gusset

PB67-43001-255

Manufactured

No

100

Each

0.0000

1

7

PR67-43001-255

Inner Tube

PB67-43001-67

Manufactured

No

100

Each

0.0000

1

7

PR67-43001-67

90° Blade Support Assembly

**

B160819 → 2

JUN 07 2017

DAS
24
9-89

**

B160822 → 2

JUN 07 2017

DAS
24
9-89

**

B160833 → 2

JUN 07 2017

DAS
24
9-89

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B160741 → 2

JUN 07 2017

DAS
24
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Friday, May 05, 2017 9:44:42 AM

Page 3

Work Order ID: 160910

160910

Parent Item: PB67-43001-13

PR67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/15/2017

Required Date: 6/2/2017

Start Qty: 7.00

Required Qty: 7.00

PB67-43001-69

Manufactured No

180

Each

1.0000

1

7

DAS

PR67-43001-69

90 Degree Cover Plate

**

JUN 15 2017

19
9-89

Location

156063

Loc Qty

Loc Code

Mezz2

1

138691

1

PB67-43001-83

Manufactured No

180

Each

6.0000

1

7

DAS

PR67-43001-83

D-Pad Assembly, Short

**

JUN 19 2017

19
9-89

Location

160825

Loc Qty

Loc Code

Mezz2

6

138687

6

2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
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SAC JF CJP							Lead hand / Supervisor Approval Verification																		
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ITEM	QTY -13	P/N	DESCRIPTION
1	X	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160910415
1705-5

B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

RELEASED
2016-11-09
SEN 16-655

D	MERGE B67-43001-13W WITH B67-43001-13, UPDATED WEIGHT B67-43001-13, REASON PAR15-437	SAD	16.11.14
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 3 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#08-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-13	SHEET 1 OF 3
APPROVED	WM	TITLE	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
DE APPR.	N/A	SCALE	NTS
DATE	16.11.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

A

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C

B

A

B67-43001-11W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

MS27039-1-10 SCREW 8
NAS1149JD0316J WASHER

B67-43001-69 90-DEGREE
COVER PLATE
REF

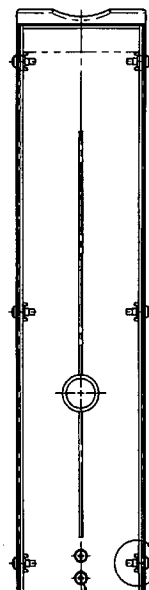
SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-69
90° COVER PLATE ASSEMBLY

B67-43001-13W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT

B67-43001-83
D-PAD ASSEMBLY, SHORT

B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY



MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL 8

C5-2

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.20 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-13W AND B67-43001-83 TO B67-43001-69



RELEASED
2016-11-09

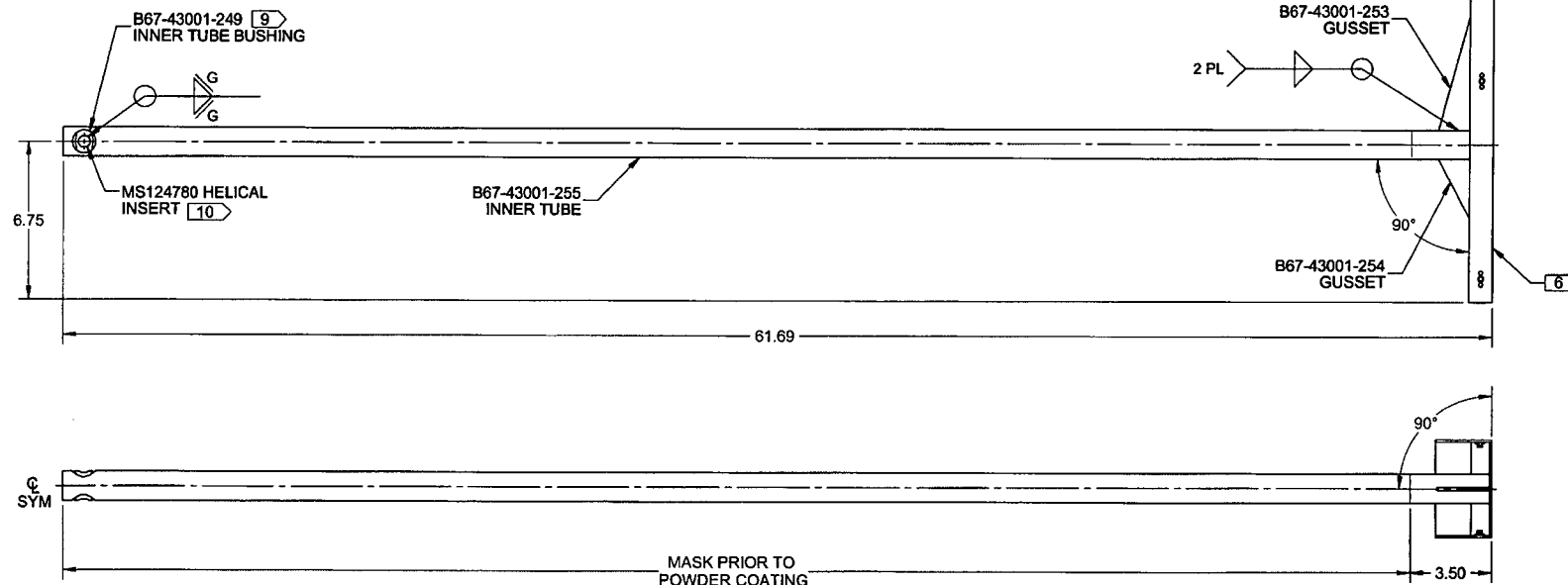
APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-13	SHEET 2 OF 3
APPROVED	WM	TITLE	AFT ADJUSTABLE BLADE
DE APPR.	N/A	SUPPORT WELDMENT	SCALE
DATE	16.11.14		NTS

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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-255	INNER TUBE
7	1	MS124780	HELICAL INSERT



B67-43001-13W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-13W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.98 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-13	SHEET 3 OF 3
APPROVED	WM	TITLE	AFT ADJUSTABLE BLADE
DE APPR.	N/A	SUPPORT WELDMENT	SCALE
DATE	16.11.14		NTS

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